

Date Wednesday, 15/08/2007 4:04:16 PM
User Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--|------------------|-----------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : LONG STEP ASSEMBLY HIGH SKID RH |
| Job Number | : 33957 | | |
| Estimate Number | : 10274 | | |
| P.C. Number | : <i>N/A</i> | Part Number | : D350591312 |
| This Issue | : 15/08/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3272 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LARGE FAB ASSY | Drawing Revision | : B |
| Previous Run | : 33378 | Material | : <i>N/A</i> |
| Written By | : <i>W</i> | Due Date | : 15/09/2007 Qty: 10 Um: Each |
| Checked & Approved By | : <i>W</i> | | |
| Comment | : Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

RS 07-08-20
10
07-08-20

| | | |
|-----|--------|------|
| 2.0 | D32721 | STEP |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: *531984 33372*

07-08-20
10

| | | |
|-----|--------|-----------|
| 3.0 | D30671 | End Plate |
|-----|--------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *332836*

07-08-20
10

| | | |
|-----|--------|---------|
| 4.0 | D32191 | Support |
|-----|--------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support *333428=3*
333860=17

07-08-20
10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:04:16 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 33957

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M103794
M104721

3-Grind End Plate flush

16.07.08.21 10
16.07.08.21 10
16.07.08.21 10

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.08.21 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/21 10RN

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

16.07.08.21 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/08/23

10.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy 632032

16.07.08.22 10

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer B33857

16.07.08.22 10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:04:16 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 33957

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

07103947

Q.M

07.08.22

10

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

Q.M

07.08.22

10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/08/23 (X10RH)

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B.32836

07.08.23 10

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 07103794

4-Grind End Plate flush

Q.M

07.08.24

10

5-Install last rivet.

Q.M

07.08.24

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: 3 Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 33957

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/27 (10)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/28 (10) 10245

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FL 07/08/30 (10) 10

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068
M 105068 BL 07-09-06
07/09/01 (10X)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

FL 07/08/04 (10)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

07/9/4

(PTC)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

333690 34-330993 (114) (264)

07/08/28 (10)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: D350-591-3/2 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: 22 Date: 07/09/10
 QA: N/C Closed: 18 Date: 07.09.10

| NCR: <u>33957</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|--------------------------------|---|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07-09-05 | 20.0 | 1 step was found with 2 red lines, that came through the powder coat. P.C. lines on material, that were not removed prior to P.C. | <u>Q51002</u> | <ul style="list-style-type: none"> Sand affected prem's to remove the P.C. and the red lines. Use 320g. Touch-up prem's with Alodine Verify by Q.C lightly re-powder coat the step while per Q51005. | <u>BR 07-09-06</u> N/A <u>BR 07-09-06</u> | <u>Q51002</u> | <u>07-09-05</u> | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 33957

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

| | | | | |
|---|----------|------------------|--|--|
| 25.0 | D2618 | Bushing | | |
| <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 2 D2618 Bushing <u>B33991</u> B3399 B3399 B3399</p> | | | | |
| 26.0 | D2856400 | Abrasion Strip | | |
| <p>Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s) Pick: Packing Kit Qty Part Number Description Batch 2 D2856-400-720 Abrasion Strip <u>B32992</u></p> | | | | |
| 27.0 | D32351 | Mounting Lug | | |
| <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 2 D3235-1 Mounting Lug <u>B33249</u></p> | | | | |
| 28.0 | D3278041 | Support Assembly | | |
| <p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D3278-041 Support Assembly <u>B33430</u></p> | | | | |
| 29.0 | AN335A | Bolt | | |
| <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 2 AN3-35A Bolt <u>M104021</u></p> | | | | |
| 30.0 | AN413A | Bolt | | |
| <p>Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 8 AN4-13A Bolt <u>M104746</u></p> | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 33957

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0 AN536A Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN5-36A Bolt M105057-

CP



32.0 AN960JD10 Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD10 Washer M104885-

CP



33.0 AN960JD416 Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 AN960JD416 Washer M104215-

CP



34.0 AN960JD516 Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M104156-

CP



35.0 MS21042L3 Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M104936-

CP



CP 07/08/2810

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:04:16 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 33957

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0 MS21042L4 Nut

Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) 17104248-
Handwritten: HHH, LHH, ES, (x10)

Handwritten: EP

37.0 MS21042L5 Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L5 Nut (or -5) 17104547-
Handwritten: HHH, LHH, ES, (x10)

Handwritten: EP

Handwritten: 07/08/28 (x10)

38.0 QC4 INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten: EP 06407 (x10)

39.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location: *REV B*

Handwritten: 07/9/2 (x10) EP

40.0 QC21 FINAL INSPECTION W/O RELEASE

Comment: FINAL INSPECTION W/O RELEASE

Handwritten: (10) 07/09/10

Job Completion



Handwritten: 07/09/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED07.06.04 *H*

B

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

GENERAL NOTES:

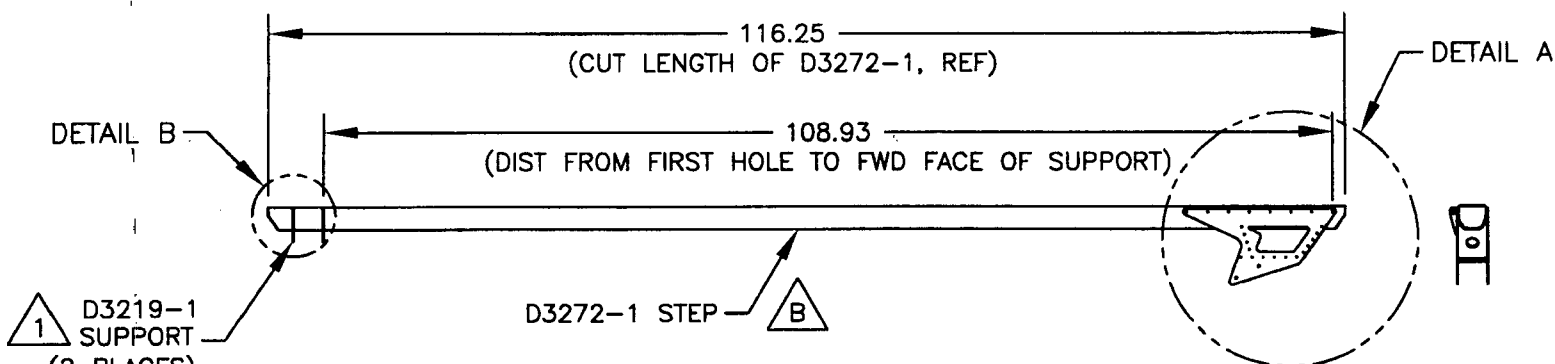
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*W/ 33957***Copyright © 2004 by DART AEROSPACE LTD**

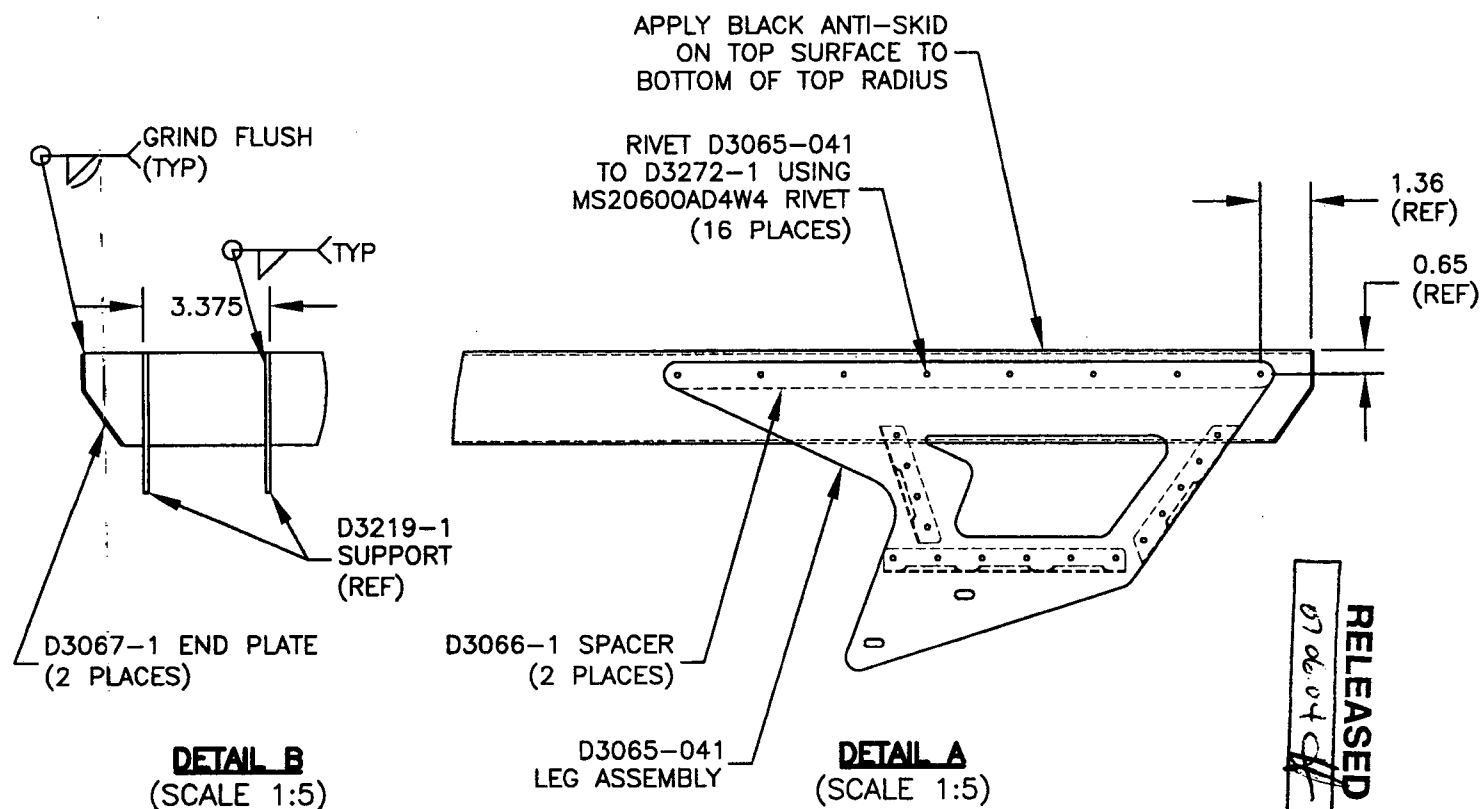
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|---------|----------|-------------|------------------------|---|
| DESIGN | 99 | DRAWN BY | BA | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | CE | APPROVED | CE | REV. B |
| DATE | 07.05.18 | DRAWING NO. | D3272 | SHEET 2 OF 3 |
| | | TITLE | STEP ASSEMBLY, HI LONG | SCALE |
| | | | | 1:20 |



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

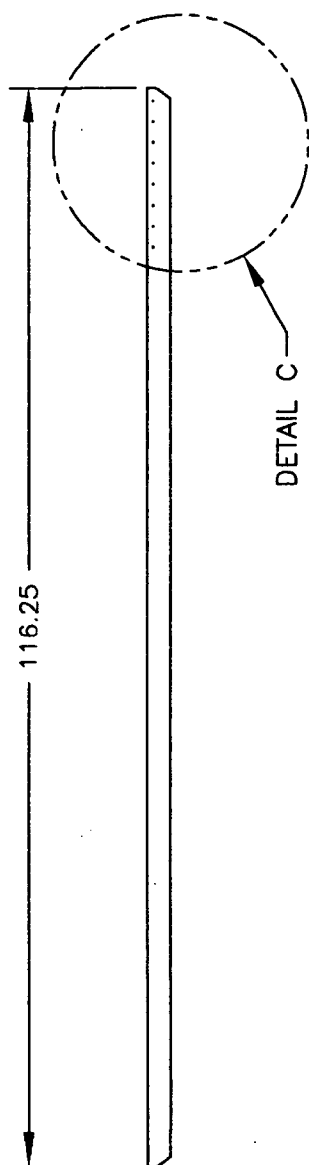




| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>JS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>JS</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |

RELEASED

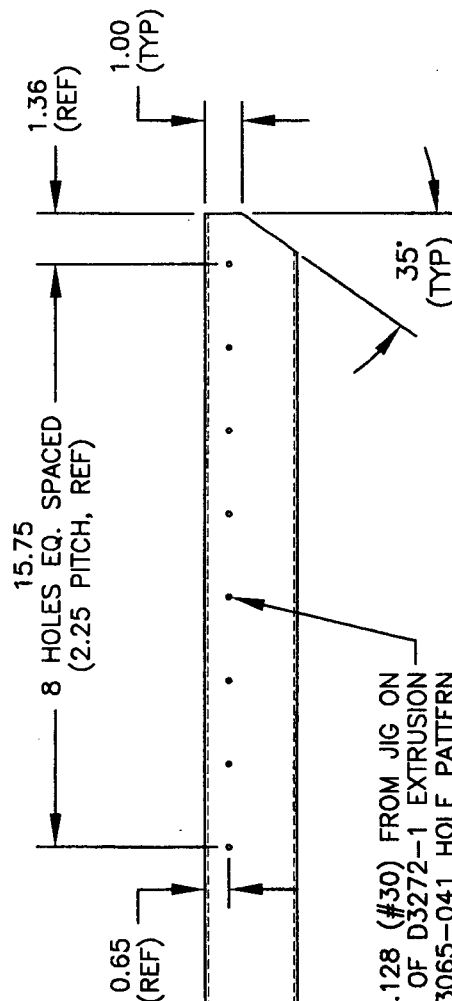
07.06.04 *JS*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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